



Flat Recess

Dimple Dies

FLAT RECESS DIMPLE DIES ARE DESIGNED TO ADD DETAIL AND STRENGTH AROUND A FASTENER WHILE MAINTAINING A FLUSH OR RECESSED HEAD. SIZES: #10, 1/4", 5/16", 3/8", 7/16", AND 1/2". AS THE DIES GET LARGER, THEY PROGRESSIVELY GET DEEPER. THIS ALSO MEANS THE LARGER THE DIE, THE MORE PRE-STRETCH OR CORRECTION WILL BE REQUIRED TO MAINTAIN A FLAT PANEL AFTER INSTALLING THE DIE. LARGER DIES WILL ALSO REQUIRE LARGER TOOLS FOR INSTALLATION. A HYDRAULIC PRESS IS RECOMMENDED FOR THESE DIES. THE 1/4" DIES WILL WORK WELL WITH OUR HF-D100 HYDRAULIC INSTALLATION TOOL. *ALWAYS USE AN ALIGNMENT PIN OR BOLT OF SOME SORT! NEVER PRESS ON THE ALIGNMENT PIN OR BOLT!!

TO INSTALL:

- 1) PUNCH OR DRILL THE SIZE HOLE THAT CORRESPONDS WITH THE DIMPLE YOU WANT TO USE.
- 2) INSERT THE MALE DIE OVER THE CORRESPONDING SHAFT OF OUR HF-D100 HYDRAULIC INSTALLATION TOOL (OR USE A BOLT, NOT PROVIDED) A PRESS OR BENCH VISE IS REQUIRED FOR THE SMALLER SIZES.
- 3) INSERT THREADED STUD (ALIGNMENT BOLT/PIN) THROUGH THE HOLE IN YOUR PANEL,
- 4) INSTALL THE FEMALE DIMPLE DIE ON THE BACK SIDE OF PANEL BY THREADING IT ON TO STUD. (SMALLER DIES HAVE NO THREADS, ONLY AN ALIGNMENT PIN-USE PRESS OR VISE)
- 5) INSTALL THE DIMPLE WITH PRESS OR HF-D100 HYDRAULIC INSTALLATION TOOL. USE ANTI SEIZE ON BOLT THREADS AND DIES.
- 6) REMOVE FEMALE DIMPLE DIE, AND ALIGNMENT BOLT. *IF THE DIES STICK TO THE PANEL TAP LIGHTLY ON THE SIDE OF THE DIES WITH A BRASS HAMMER TO REMOVE.

THESE DIMPLE DIES ARE CNC MACHINED FROM 4140 STEEL AND ARE RATED FOR UP TO 18GA MILD STEEL, 20GA STAINLESS STEEL, OR 16GA ALUMINUM MADE IN TEXAS!

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